

Work Order ID 132096 -1

Friday, April 24, 2015 11:41:13 AM

132096

ASAP

Page 1

Item ID: D206-628-023RLC
 Revision ID:
 Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4
 Start Date: 4/24/2015 Start Qty: 4.00
 Required Date: 4/24/2015 Req'd Qty: 4.00
 Reference:

SPLIT

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:
 Customer:

Approvals: Process Plan: MCS Date: 15-04-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D206-628	REV G

100	Document Control	0.00							DAS 02 9-89
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100

DC

Doc.Control -USB or Paperwork

Memo

Photocopy blue file and type labels as per PPP D206-628-023 CHG 003

JUN 30 2015

110	Pick Kit	0.00							
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110

Packaging

Packaging

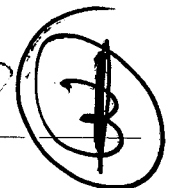
Memo

0.00

DAS
27
9-89

APR 27 2015

DAS
27
9-89



120	QC4- 100% Inspect kits for completeness	0.00							
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120

QC

Quality Control

Memo

0.00

DAS
02
9-89

SEP 23 2015

B131491

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Work Order ID 132096

132096

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Friday, April 24, 2015 11:41:13 AM

Item ID: D206-628-023RLC Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4
 Start Date: 4/24/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/24/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00				1			DAS 02 9-89
130	Memo	0.00							
Packaging	Identify and pack for shipping as per PP206-628-023								SEP 23 2015
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140	Memo	0.00							
QC									
Quality Control									

20130920
 SA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

Picklist Print

Friday, April 24, 2015 11:41:16 AM

Page 1

4

Work Order ID: 132096

132096

Parent Item: D206-628-023RLC

D206-628-023RLC

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.09.23 NEW ISSUE LL VERF:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4C14A

Purchased

No

120

Each

113.0000

4

16

AN4C14A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

25

118706

20

123021

5

ST312A

50

131677

50

ST344

38

m130716

13

m131452

25

**

DAS
27
9-89

DAS
26
9-89

AN4C15A

Purchased

No

120

Each

77.0000

8

32

AN4C15A

Bolt

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

ST343

67

M130716

50

M131377

17

**

DAS
27
9-89
APR 27 2015

DAS
26
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 132096

132096

Parent Item: D206-628-023RLC

D206-628-023RI C

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

D2731-7

Manufactured No

120

Each

60.0000

4

16

D2731-7

Mounting Lug

DAS
02
9-89

Location

Loc Qty

Loc Code

ST520

36

116802

36

ST532A

24

129255

24

**

DAS
27
9-89

DAS
27
9-89

D2732

Manufactured No

120

f

629.5000

2

8

D2732

Rubber Cushion (\$per foot)

DAS
02
9-89

Location

Loc Qty

Loc Code

ST412

420.5

117118

420.5

ST639

209

117118

209

**

DAS
27
9-89

DAS
27
9-89

(D2732-030) Cut (8) at 3.00"

D2842-041

Manufactured No

120

Each

0.0000

1

4

D2842-041

Step Assembly, 206 Float

DAS
02
9-89

~~*~~

**

13/491

DAS
27
9-89

D3394-043

Manufactured No

120

Each

9.0000

4

16

D3394-043

Lug

DAS
02
9-89

Location

Loc Qty

Loc Code

ST528

9

124220

9

**

APR 27 2015

~~B13174~~

B13174

12x B132499

DAS
27
9-89

Friday, April 24, 2015 11:41:16 AM

Shop Packet Print

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					

Picklist Print

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Work Order ID: 132096

132096

Parent Item: D206-628-023RLC

D206-628-023RI C

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

120

Each

1,079.000

12

48

MS21043-4

Nut

DAS

27

9-89

DAS

26

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

367

m128798

367

ST304

672

m128818

34

m131697

638

48

NAS1149C0432R

Purchased

No

120

Each

3,543.000

24

96

NAS1149C0432R

WASHER

DAS

27

9-89

DAS

26

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

GA

2206

m125807

476

m131467

1730

ST271

1337

m131452

1337

96

NAS1515H3

Purchased

No

120

Each

555.0000

3

12

NAS1515H3

Washer

DAS

27

9-89

DAS

26

9-89

DAS

02

9-89

Location

Loc Qty

Loc Code

FG

10

123301

10

GA

44

m129521

44

ST266

501

m128635

13

m131697

488

12

APR 27 2015

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Shop Packet Print

Page 3

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Picklist Print

Friday, April 24, 2015 11:41:17 AM

Page 4

Work Order ID: 132096

132096

Parent Item: D206-628-023RLC

D206-628-023RI C

Parent Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4

Start Date: 4/24/2015

Required Date: 4/24/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4L

Purchased

No

120

Each

337.0000

21

84

***NAS1515H4I ***

Washer

DAS
27
9-89

DAS
26
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

2

103691

2

ST260a

335

~~m131026~~

96

m131624

8

~~m131697~~

231

APR 27 2015

13

71

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

DAS
02
9-89

REFERENCE ONLY

D206-628-023	D206-628-024	D206-628-033	D206-628-034	Part Number	Description
2	2	2	2	D2844-1	ARM
1	1	1	1	D2844-3	ARM
3	3	3	3	AN3C4A	BOLT
3	3	3	3	NAS1149C 0363R	WASHER (or AN960C10)
3	3	3	3	NAS1515H 4L	WASHER

A large, handwritten signature or scribble in black ink, consisting of several loops and a long horizontal stroke, positioned below the table.

Work Order ID 132096

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132096

ASAP

Page 1

Item ID: D206-628-023RLC Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access-Step™ LH - High Gear, Float Compatible 206L/L1/L3/L4
 Start Date: 4/24/2015 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 4/24/2015 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MCS Date: 15-04-24 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D206-628	REV G								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels as per PPP D206-628-023 CHG 003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
27
3-29

MCS 15-04-28
 (4)

4X
 DAS
27
3-29

APR 27 2015